

5/44

DART AEROSPACE LTD		Work Order:	24267
Description: Bracket Assembly		Part Number:	D3183-044
Dwg: D3183 Rev. C		Qty:	3 units <i>kg</i>
Page 1 of 1			

04.02.27

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	<i>MS</i>	05.09.14	3
2	MV	Cut blank: (1.500" x 2.000") 5.500" long Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B2.000x01.500) Identify for D3183-4 Batch: <u>M14773</u>	<i>MS</i>	05/10/12	3
3	MV	Machine D3183-4 as per Folio FA322 and Dwg D3183 Identify as D3183-4	<i>MS</i>	05/10/16	3
4	QC2	Inspect parts as they come off the CNC machine	<i>MS</i>	05/10/16	3
5	MV	Deburr	<i>MS</i>	05/10/16	3
6	MV	Scribe batch number	<i>MS</i>	05/10/16	3
7	QC8	Second check	<i>MS</i>	05/10/16	3
8	GA	Assemble D3183-044 as per Dwg D3183. (Note: D3183-4 is on BOM as material from Step 2) Pick: Qty: Part Number Description Batch 2 D3121-21 Bolt <u>D23914</u> 2 D3183-045 Bearing Assembly <u>B23974</u> Identify as D3183-044	<i>En</i>	05/10/17	3
9	QC5	Inspect work to Step 8	<i>MS</i>	05/10/17	3
10	ST	Identify and Stock	<i>CL</i>	05/10/19	3
11	AC	Cost / part			
12	DC	Close W/O Inspect Level 21	<i>MS</i>	05/11/23	3

Rev	Date	Change	Revised By	Approved
<i>AB</i>	04.02.18	New issue	KJ/DS	<i>MS</i>

RF 04.02.19

RELEASED
04.02.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DP Date: 05/11/23

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	24267
Description: Bracket		Part Number:	D3183-4
Inspection Dwg: D3183	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R.190"	✓			
R0.063	+/-0.010	R.063"	✓			
0.182	+/-0.010	.182"	✓			
0.070	+/-0.010	.07"	✓			
0.100	+/-0.010	.100"	✓			
Ø0.201 x 0.100	+/-0.010	Ø.197" x .100"	✓			
0.182	+/-0.010	.182"	✓			
5.32	+/-0.030	5.32"	✓			
5.036	+/-0.010	5.038"	✓			
2.120	+/-0.010	2.12"	✓			
1.290	+/-0.010	1.290"	✓			
0.365	+/-0.010	.367"	✓			
0.218	+/-0.010	.214"	✓			
1.030	+/-0.010	1.032"	✓			
1.90	+/-0.030	1.89"	✓			
1.012	+/-0.010	1.017"	✓			
Ø0.201 x 0.100	+/-0.010	Ø.199" x .100"	✓			
0.182	+/-0.010	.181"	✓			
0.786	+/-0.010	.788"	✓			
Ø0.392	+0.002/-0.000	.393"	✓			
R0.19	+/-0.030	R.19"	✓			
3.954	+/-0.010	3.960"	✓			
0.162	+/-0.010	.169"	✓			
R0.19	+/-0.030	R.19"	✓			
R0.25	+/-0.030	R.250"	✓			
4.26	+/-0.030	4.261"	✓			
2.800	+/-0.030	2.800"	✓			
Calculated dimension						
0.162	+/-0.010	.162"	✓			
* 0.615	+/-0.010	.610"	✓			
0.435	+/-0.010	.431"	✓			
0.200	+/-0.010	.200"	✓			
0.381	+/-0.010	.380"	✓			
0.032	+/-0.010					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	

RELEASED

04.06.17